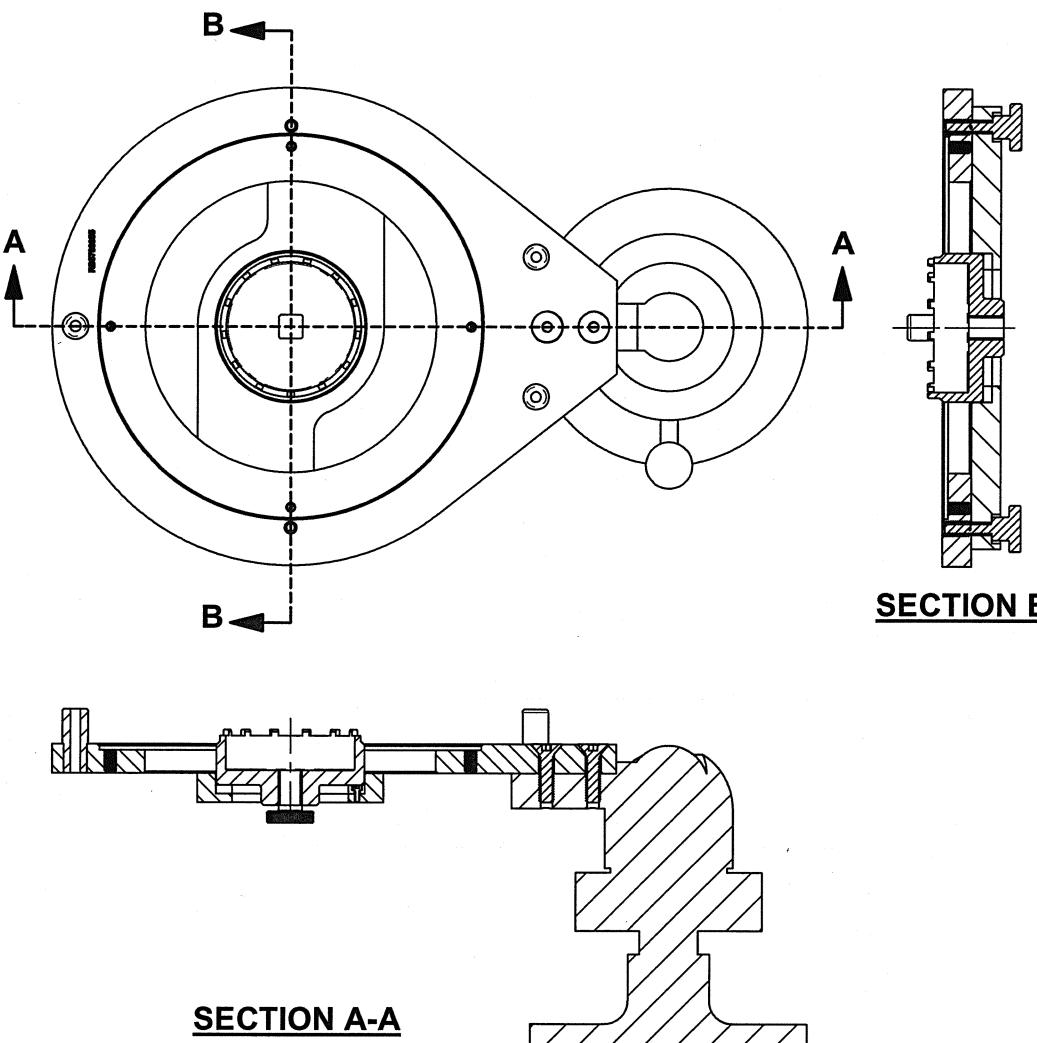
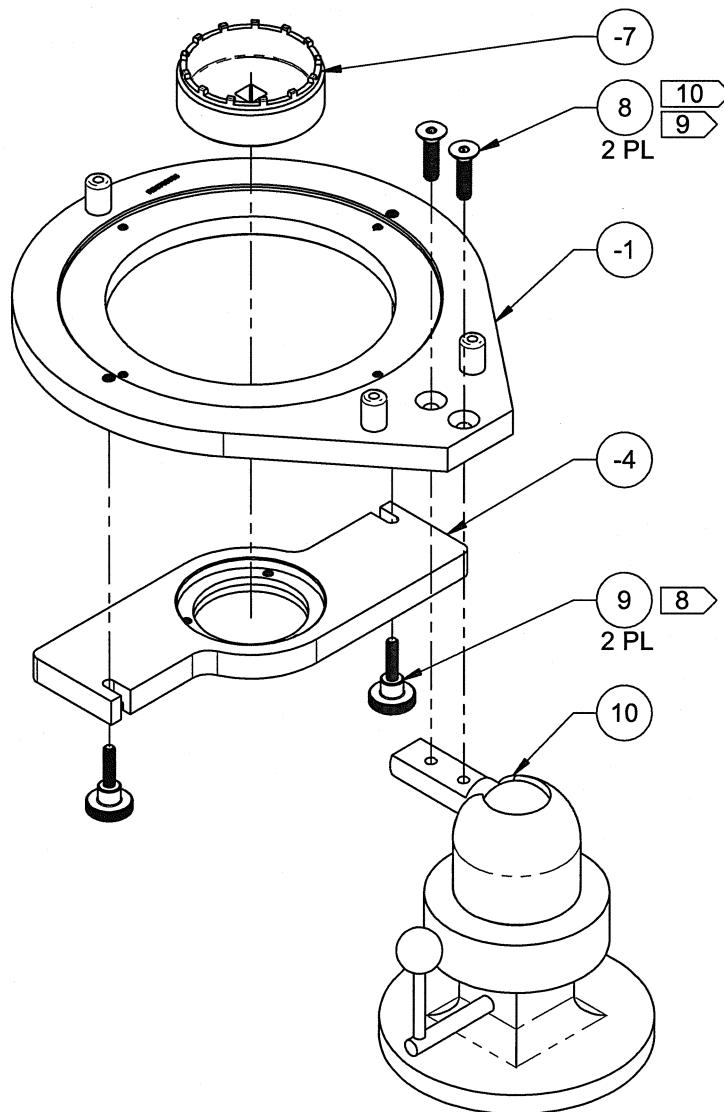


ITEM #	QTY	PART #	PART TITLE
-1	1	RB6799955-1	PLATE ASSY
-4	1	RB6799955-4	WRENCH RETAINER ASSY
-7	1	RB6799955-7	WRENCH
8	2	McMaster#91263A731 OR EQUIV	ZINC PLATED STEEL HEX DRIVE FLAT HEAD SCREW 5/16"-18 X 1-1/4" LG.
9	2	McMaster#91882A429 OR EQUIV	BLACK OXIDE STEEL KNULED-HEAD THUMB SCREW 1/4"-20 X 1" LG. X 1" DIA. HEAD
10	1	WILTON #301 OR EQUIV	STEEL POWER ARM TWO MOUNTING HOLES 5/16"-18 X 1" APART



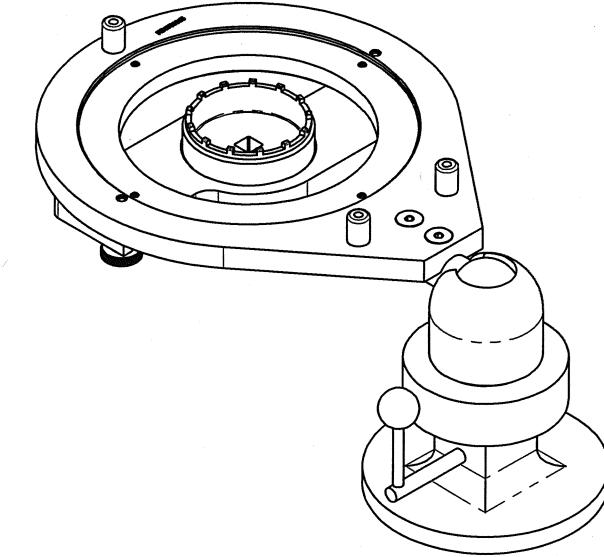
NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLE AS SHOWN
 8) INSTALL ITEM 9 HAND TIGHT
 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 8 THEN ASSEMBLE WITH ITEM -1 AND ITEM 10, AND REMOVE EXCESS
 10) INSTALL ITEM 8 HAND TIGHT
 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RB6799955 TURBINE FIXTURE ASSEMBLY

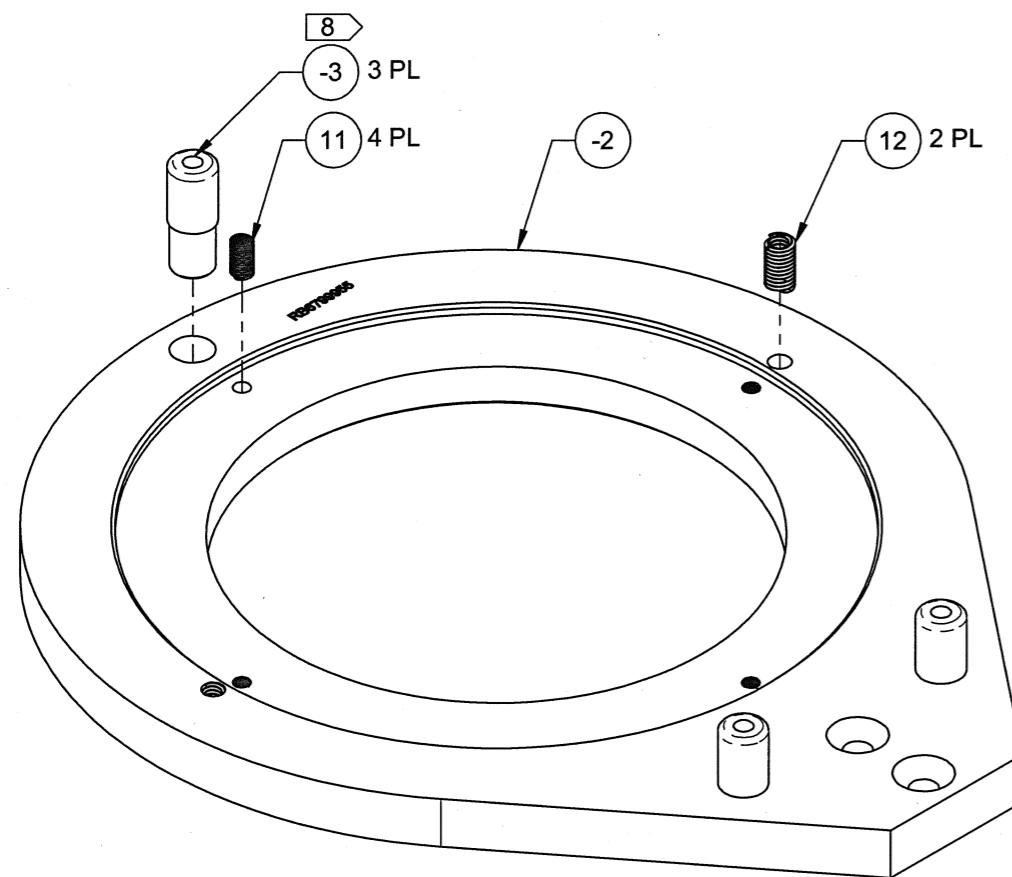
11



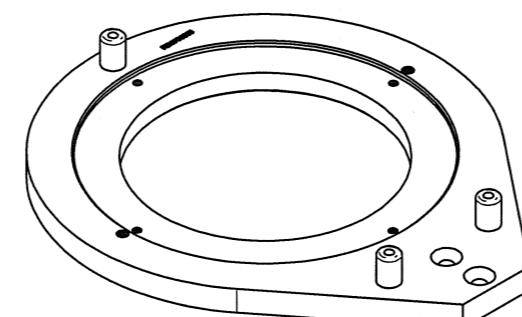
SEE PREVIOUS PDFs FOR OLDER REVs
 TEMPLATE UPDATED PER DART HBY STANDARDS
 ITEM -1 CHANGED FOR ITEM -2
 ITEM -2 McMaster#91263A585 CHANGED FOR ITEM 8
 McMaster#91263A731
 ITEM -3 CHANGED FOR ITEM 11
 ITEM 12 McMaster#91732A735 ADDED
 ITEM -4 CHANGED FOR ITEM 10
 ITEM -6 CHANGED FOR ITEM -5
 ITEM -7 CHANGED FOR ITEM -6
 ITEM -8 McMaster#91251A106 CHANGED FOR ITEM 13
 McMaster#90128A106
 ITEM -9 CHANGED FOR ITEM -7
 ITEM -10 AND ITEM -11 REPLACE BY PURCHASE PART ITEM 9
 McMaster#91882A429
 ITEM -12 CHANGED FOR ITEM -3
 ITEM -1 AND ITEM -4 ASSY ADDED
 ITEM -2 DIMENSION 4.625 +/- .002 REPLACED BY 9.887 +/- .001, DIMENSION 3X Ø .4981/.4971 CHANGED FOR Ø .5000/.4992, DIMENSION 2X 1.500 +/- .002 REPLACED BY 3.000 +/- .001, DIMENSION 2X 1/4-20 UNC-2B CHANGED FOR TAP FOR 1/4-20 HELICOIL, DIMENSION 4.312 +/- .002 REPLACED BY 8.624, DIMENSION R5.13 CHANGED FOR Ø 10.25, ENGRAVING S/N AND "MADE IN USA" REMOVED, MATERIAL 6061 CHANGED FOR 6061-T6/7075-T6, FINISH CLEAR ANODIZE CHANGED FOR RED ANODIZE, DIMENSION 5.500 ADDED, DIMENSION 0.500 REMOVED, DIMENSION 1.00 REMOVED
 ITEM -3 MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 Rc), FINISH BLACK OXIDE CHANGED FOR ZINC PLATE YELLOW, DIMENSION .625 CHANGED FOR 0.625 +/- .005, DIMENSION R0.008 MAX ADDED, DIMENSION 0.03 X 45.0° CMF ADDED, DIMENSION Ø .550 CHANGED FOR Ø 0.550 +/- .005, DIMENSION Ø .4990/.4986 CHANGED FOR Ø 0.5008/0.5000
 ITEM -5 MATERIAL 6061 FINISH CLEAR ANODIZE CHANGED FOR 6061-T6/7075-T6 FINISH RED ANODIZE, DIMENSION 4.312 +/- .002 REPLACED BY 8.624 +/- .001, DIMENSION 60.0° ADDED, DIMENSION 2X L .625 +/- .002/-0.19 CHANGED FOR Ø 0.63, DIMENSION 2X .31 CHANGED FOR 0.281 2 PL, DIMENSION R0.008 MAX ADDED, DIMENSION 2.50 2 PL ADDED, DIMENSION 0.03 X 45.0° CMF ADDED
 ITEM -6 MATERIAL DOM CHANGED FOR A36/1018/1020/1025 HR, FINISH BLACK OXIDE CHANGED FOR ZINC PLATE YELLOW, DIMENSION 120.0° 2 PL ADDED
 ITEM -7 MATERIAL 4140/4142 RC 32-36 CHANGED FOR O1 48-52 Rc, DIMENSION 27.7° 12 PL ADDED, DIMENSION R0.03 ADDED, DIMENSION Ø 2.780/2.770 CHANGED FOR Ø 2.775, DIMENSION Ø 3.190/3.180 CHANGED FOR Ø 3.185

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		DART AEROSPACE LTD
DRAWN	VM		HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT		TOOL PART #
MFG. APPR.	JFC		RB6799955
APPROVED	WJ		REV. F
DATE	2019-06-26		SHEET 1 OF 8
			TITLE
			TURBINE FIXTURE ASSEMBLY
			SCALE
			NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB6799955-2	PLATE
-3	3	RB6799955-3	LOCATOR
11	4	McMaster#91732A726 OR EQUIV	18-8 SS HELICAL INSERT #10-32 X 0.475" LG.
12	2	McMaster#91732A735 OR EQUIV.	18-8 SS HELICAL INSERT 1/4"-20 X 5/8" LG.

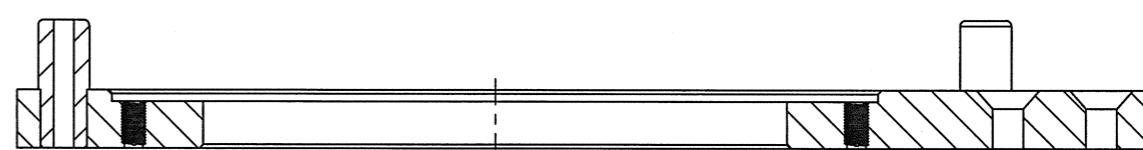
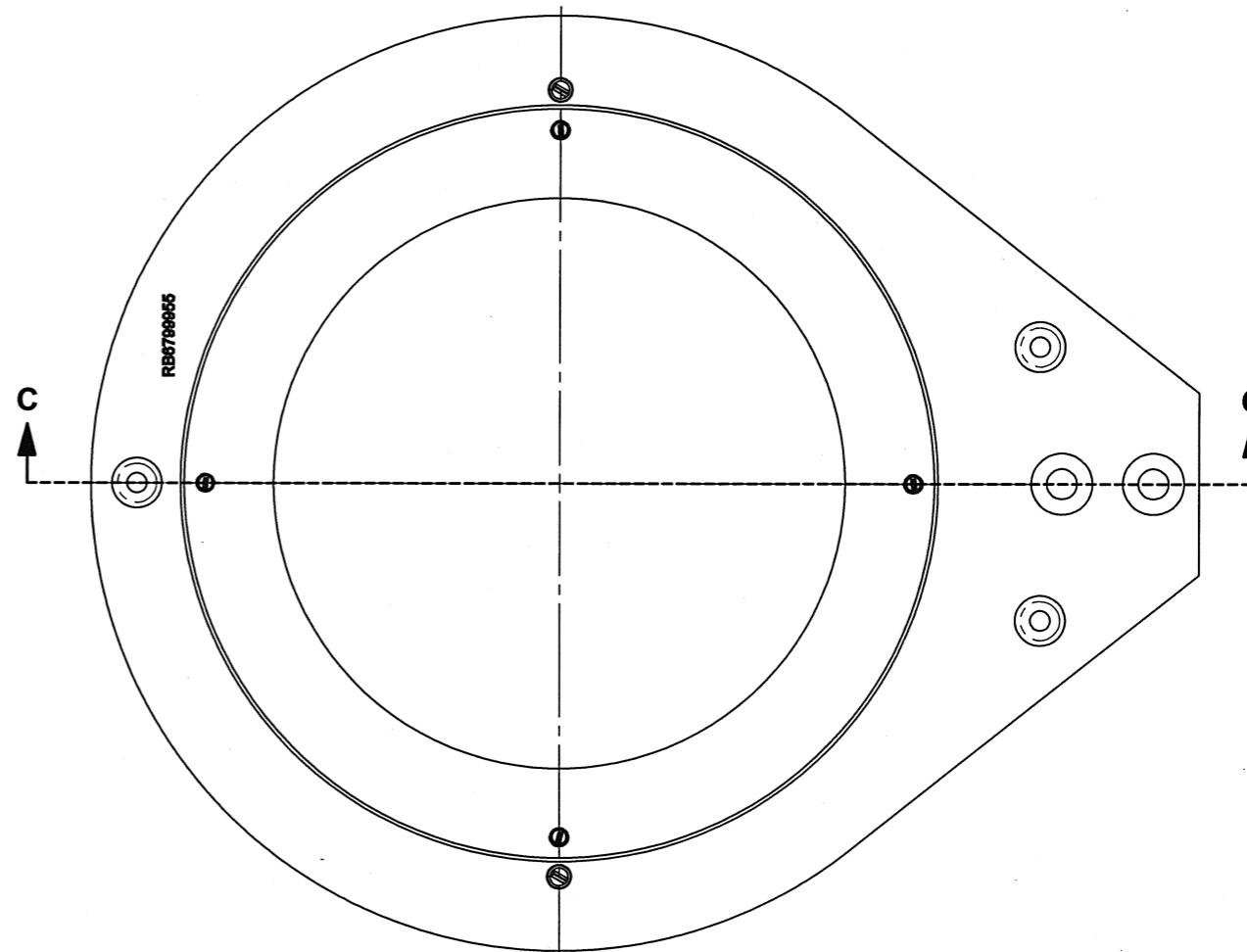


RB6799955-1 PLATE ASSY



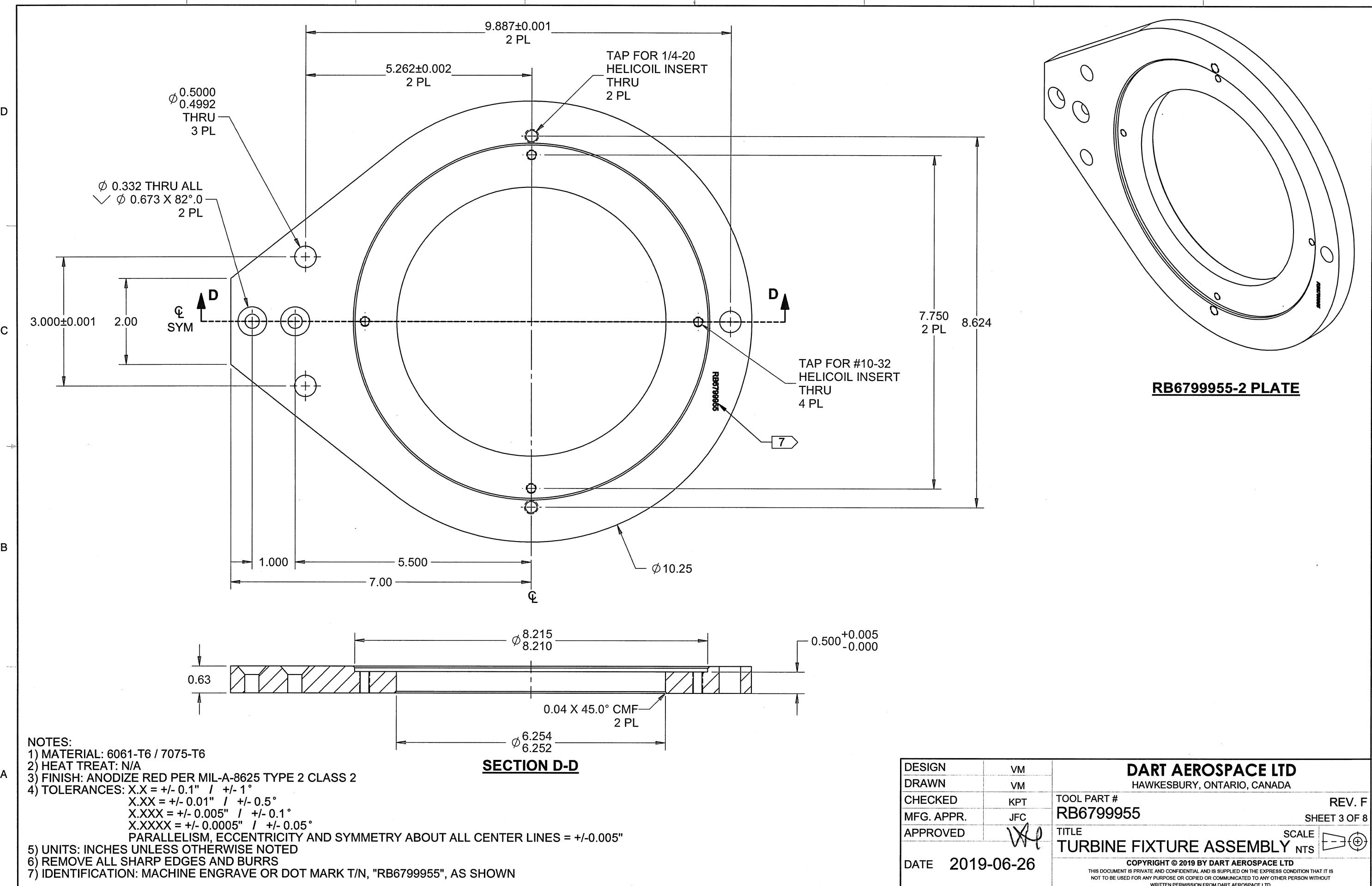
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$
X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$
X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -3 WITH ITEM -2, AND REMOVE EXCESS



SECTION C-C

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 2 OF 8
APPROVED	WY	TITLE	SCALE
		TURBINE FIXTURE ASSEMBLY NTS	
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DESIGN	VM	DART AEROSPACE LTD			
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA			
CHECKED	KPT	REV. F			
MFG. APPR.	JFC	SHEET 3 OF 8			
APPROVED	<i>[Signature]</i>	TITLE			
DATE	2019-06-26	SCALE			
RB6799955					
TURBINE FIXTURE ASSEMBLY NTS					

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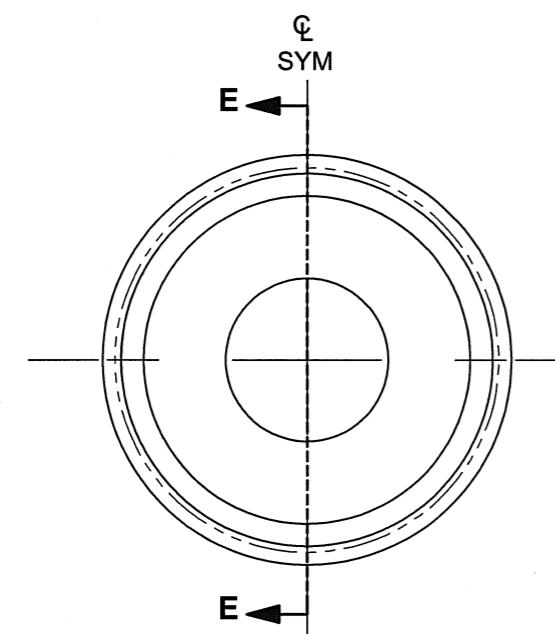
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C

C

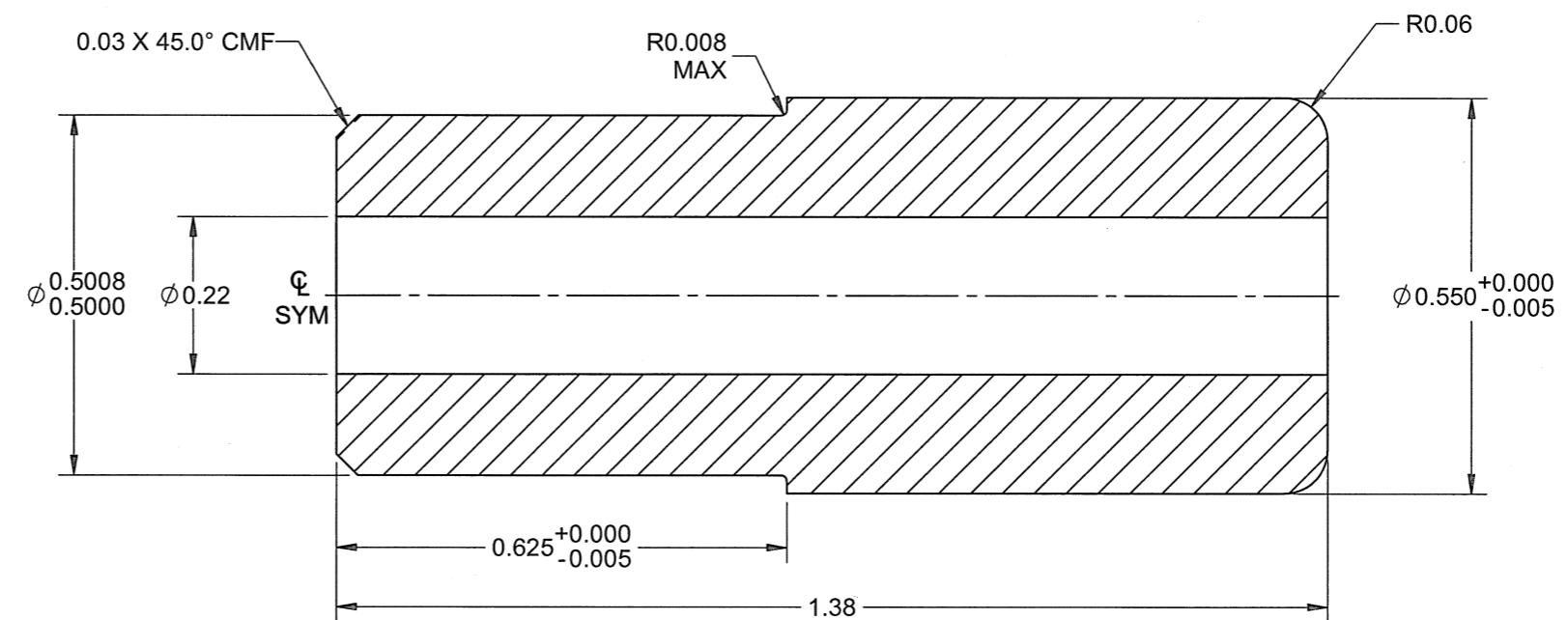
B

B



RB6799955-3 LOCATOR

8



SECTION E-E

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	WJ		
DATE 2019-06-26		TOOL PART #	RB6799955
		REV. F	SHEET 4 OF 8
TITLE		SCALE	
TURBINE FIXTURE ASSEMBLY		NTS	

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ITEM #	QTY	PART #	PART TITLE	
-5	1	RB6799955-5	WRENCH RETAINER PLATE	
-6	1	RB6799955-6	SPACER	
13	3	McMaster#90128A106 OR EQUIV	ZINC PLATED STEEL SOCKET HEAD CAP SCREW #4-40 X 1/4" LG.	

RB6799955-4 WRENCH RETAINER ASSY

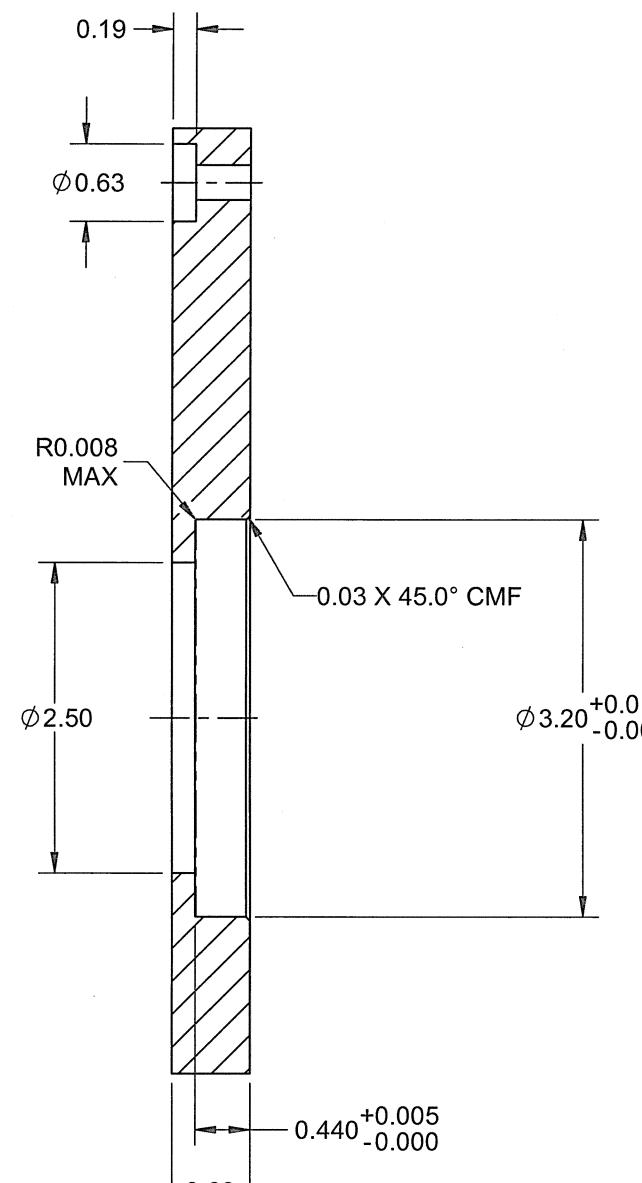
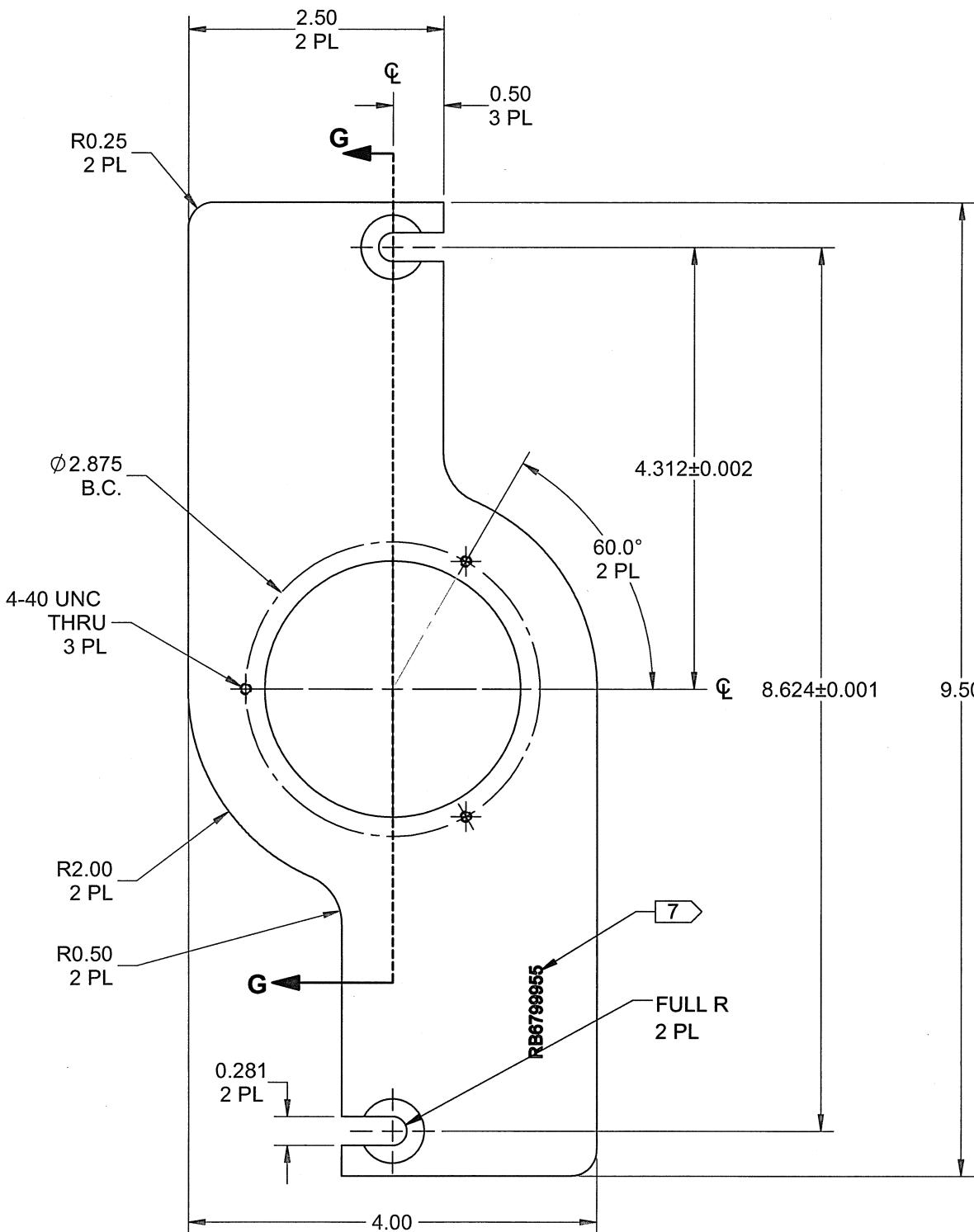
NOTES:

1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 $X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$$
 $X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$$
 $X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLE AS SHOWN
 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 13 THEN ASSEMBLE WITH ITEM -6 AND ITEM -5, AND REMOVE EXCESS
 9) INSTALL ITEM 13 HAND TIGHT

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	REV. F
MFG. APPR.	JFC	SHEET 5 OF 8
APPROVED	<i>WJ</i>	TITLE
DATE 2019-06-26		SCALE

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RB6799955-5 WRENCH RETAINER PLATE

SECTION G-G

NOTES

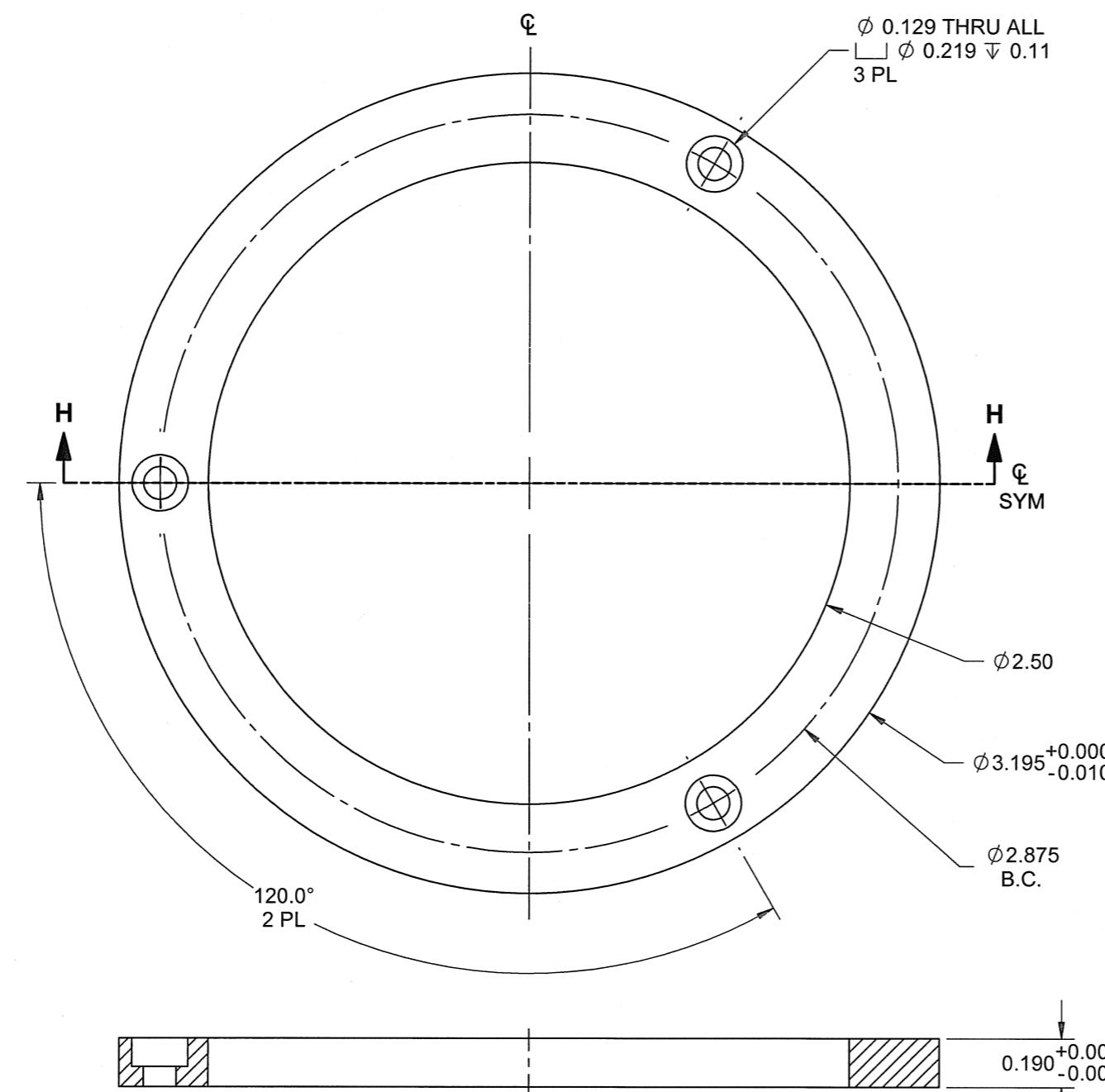
NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $+\/-0.1"$ / $+\/-1^\circ$
X.XX = $+\/-0.01"$ / $+\/-0.5^\circ$
X.XXX = $+\/-0.005"$ / $+\/-0.1^\circ$
X.XXXX = $+\/-0.0005"$ / $+\/-0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/-0.005$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N. "RB6799955". AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	SHEET 6 OF 8
APPROVED	<i>Vf</i>	TITLE	SCALE
DATE	2019-06-26	TURBINE FIXTURE ASSEMBLY NTS	

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RB6799955-6 SPACE

8

NOTES

1) MATERIAL: A36/1018/1020/1025 HR
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.001" (0.025 mm)
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. F
MFG. APPR.	JFC	RB6799955	
APPROVED	<i>Wf</i>	TITLE	SCALE
DATE	2019-06-26	TURBINE FIXTURE ASSEMBLY	
NTS			
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